102241

Page 1

May-2/-13 12:4	12:00 PM	;		merie in in in							
Revision ID:	D4095-047 Wearpad Ass	embly		Accept	*N900	040	100)*	Setup Star Stop	IVI	S1* S2*
	6/14/13 6/14/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item I Customer:	D:					• • • • • • • • • • • • • • • • • • • •
Approvals:	Process Pl	an:ML5	Date: 13-05-2	& Tooling:	D:	ate:		I	Run Star	1/	R1*
					D:	ate:			Sto	*N	R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Re	vision Nbr		· ······ · · · · · · · · · · · · · · ·							
D4095	В										
100		FLOW WATER JET		0.00				17	for EZ	13-6	10
Waterjet FLOW CNC Waterj 304,063	et	Memo 1-Cut as per Dwg Rev:_ Prog Rev:_ 2-Deburr if	\triangleright	0.00				6			
110		QC2- Inspect parts off n	nachine FAI/FAIB	0.00							
110 QC Quality Control		Мето		0.00			-	<u> </u>	Jn El	13-	6-10
120		QC8- Inspect parts - sec	ond check	0.00 AS				\sim			
120 QC Quality Control		Memo		0.00	foletio			(417)		

											DQA:	Date	:
NCR:	Yes	/ No				WORK ORDER NON-C	100	VFORM	MANCE / UP	PDATE	OA Classic	Doto	
											QA Closed:	Date	<u>:</u>
Work Ord	or.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Ord	-					Rework	1		Skid-tube	Crosstube]	Water Jet	Engineering
Part 1	No.					Scrap]	ſ	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	-					Use-as-is]		noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR I	No.					Work Order Update]		Large Fab	Composite]	Supplier	
Post	ī		1		Doscri	ption of work order update		Initial	٨	ction	Sign &		
Root Cause		Date	Step	Qty		or Non-conformance	1	nief Eng		cription	Date	Verification	QC Inspector
Doc/Data	\sqcap	Date	Step	Qty		or Non-comormance		ilei Liig	Desc	cription	Date	Vermedion	QC IIISPECTOI
Equip/Tooling	H												
Operator	H												
Material	П						1						
Setup	П											Į Į	
Other												1	
Process													
Supplier												1	
Training													
Unapproved							L						
		·				F	AUI	LT CATE	GORY				
Land	ing (Sear				General	_	,		_	7	_	-
		Bending			_	Bend	<u> </u>	Grain		L	Ovalized		Pressure/Forced
	$ldsymbol{f eta}$	Centre N	ot Concer	ntric to	o/s	BOM/Route	lacksquare	Hardwa			Over/Under	j	Temperature/Cure
		Cracks				Broken/Damaged	<u> </u>	4	ion Incomplete	_	Part Incorre	<u> </u>	Weld
		Crushed/	Crimped		_	Burrs	\vdash	-1	ions Incomplete	/Unclear	Part Lost/M		Wrong Stock Pulled
	\vdash	Cuffs			<u> </u>	Contamination	-	Mainte		-	Part Moved		
	\vdash	Heat Trea				Countersink	\vdash	Mislabe		<u> </u>	Positioned \	· ·	٦۵
	\vdash	Inspectio		fube	⊢	Cut Too Short	\vdash	Misread			Power Loss	Surge	Other
	Ripples in Bend Drill Holes			-	Offset.	•			<u> </u>				
	1	Torque V	Vaves in E	Extrusio	n	Drawing	1.	Out of	Calibration				

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

May-27-13 12:42:00 PM

Item ID:

D4095-047

6/14/13

QC:

Accept

N900040100

Setup Start

Revision ID:

Start Date:

Item Name:

Wearpad Assembly

Start Qty: 4.00 **Req'd Qty:** 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Required Date: 6/14/13

Date: _____

Date:

Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date:

Start

Stop

Stop

Sequence ID/ Work Center ID

130

130

Brake NC

Operation Description

Form as per dwg

NC BRAKE

Memo

Memo

0.00

0.00

Date: Tool ID

Tool # Plan Accept Qty Code

Reject Qty

Run

Reject Number Stamp

Insp.

Brake NC

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

150

150 Large Fab

Large Fab

Weld per dwg A/R Hardcoat S.S. Batch: M124597 0.00

Large Fab

Memo

0.00

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NO	ON-C	ONFORM	MANCE / UP	DATE	. 	D-4	
						T					QA Closed:	Date:	
Work Orde	eř.					DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS	
Work Orde	C1				****	Rewo	ork 🗍		Skid-tube	Crosstube	7	Water Jet	Engineering
Part I	No.					Scr	-		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	-					Use-as		1	noforming	Finishing		re/Packaging	Other
NCR I	No					Work Order Upda	ate		Large Fab	Composite]	Supplier	
			1								l c: 0		
Root			_	_		ption of work order upd		Initial		tion	Sign &		
Cause	\longrightarrow	Date	Step	Qty	. (or Non-conformance		Chief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data	Ш												
Equip/Tooling	Ш								,				
Operator	Ш								_				,
Material													·
Setup					• .	•							
Other	Ш		ļ				Ì		,				
Process	Ш					•							
Supplier	Ш	•											
Training	Ш		1						,				ĺ
Unapproved						•					·		
	٠		•				FA	ULT CATE	GORY				
Land	ing G	ear			_	General					_		-
		Bending	. •			Bend		Ġrain			Ovalized		Pressure/Forced
		Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	ire		Over/Under	tolerance	Temperature/Cure
		Cracks	•		L.	Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ct	Weld
		Crushed/	Crimped			Burrs		Instruct	tions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Part Moved

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

May-27-13 12:42:00 PM

Item ID: D4095-047 Revision ID: Item Name: Wearpad Assembly			Accept	*N900040	1100)* 5	Setup Start Stop	*N:	S1*	
	6/14/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item ID: Customer:				I VI	
Approvals:	Process Pla	an:	Date:	Tooling:	Date:		I	Run Start	*N	R1*
	QC:		Date:	SPC (Y/N):	Date:			Stop	*N	R2*
Sequence ID/ Work Center ID 160 *160* QC Quality Control		Operation Description QC10- Inspect visual per Memo QC5- Inspect part comple		Set Up/ Run Hours 0.00 0.00		Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Quality Control 180 *180* HandFinish Hand Finishing		DWG	TIRE TOP (CONCAVE) SU GUARD BATCH: \	0.00 0.00 URFACE WITH ROCKGUA	RD AS PER		_17	<u>ø</u> _	Ø	13-7-

NCR: Y	'es /	No				WORK ORDER NON-C	O	VFORM	MANCE / UPI	DATE			
	-								•		QA Closed:	Date	
Work Orde	er:				•	DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part N						Rework Scrap Use-as-is Work Order Update		1	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root					Descri	tion of work order update		nitial	Act	ion	Sign &		
Cause	D	ate	Step	Qty		or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling		İ	1										
Operator													
Material													
Setup		1											
Other									į				
Process							1						
Supplier	Ш												
Training													
Unapproved													
				·	·····		AUL	T CATE	GORY				
Landi	ng Gear					General		I			1	Γ	-
	lacksquare	ding				Bend	L	Grain			Ovalized		Pressure/Forced
	— —		t Concer	ntric to (^{D/S}	BOM/Route	<u> </u>	Hardwa			Over/Under	 	Temperature/Cure
	Cra				<u> </u>	Broken/Damaged	<u> </u>	1	ion Incomplete	–	Part Incorred	<u> </u>	Weld
	-		rimped		<u> </u>	Burrs	_	1	tions Incomplete/U	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuf				-	Contamination	<u> </u>	Mainte		ļ	Part Moved	_	
	$oldsymbol{oldsymbol{ ext{H}}}$	it Treat			<u> </u>	Countersink	\vdash	Mislabe		_	Positioned V		٦٠٠٠
	— 1		Strip in	Tube	_	Cut Too Short	<u></u>	Misrea	d		Power Loss/	Surge	Other
	—	ples in			<u> </u>	Drill Holes	\vdash	Offset			-		
	$oldsymbol{oldsymbol{ o}}$	•	aves in E		ı	Drawing	-	1	Calibration				****
	Tur	ning Se	equence		- 1	Finish	1	Out of :	Sequence				

Outside Dimensions

DQA:

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio

Work Ord 6 <i>May-27-13 12:4</i>		2241		*102	241*			- '				Page 4
Revision ID:	D4095-047			Accept	*N900	040	100)*	Setup	Start Stop	*N:	S1* S2*
	Wearpad Asse 6/14/13 6/14/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*	·	Cust Item I Customer:	D:					· IN	
Approvals:	Process Pla	ın:	Date:	Tooling:	D:	ate:]	Run	Start	*NI	R1*
	QC:		Date:	SPC (Y/N):	Da	ate:				Stop	*N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Re Qt	•	Reject Number	Insp. Stamp
190		QC3- Inspect Part Finish	ı	0.00								Stamp DAS 05
190 QC Quality Control		Memo		0.00				17				<u>**** 13.0</u>
200		Identify as per dwg & St	ock Location: FD-(O.00 DO				(•	/	HD	10/0
200 Packaging Packaging		Мето		0.00				<u> </u>		-\$-	<u> </u>	131071
*210 *21 0 *		QC21- Final Inspection	- Work Order Release	0.00					(3/	1/9	1
QC		Memo		0.00							•	

Quality Control

17/11/6) mf 13-7-9

											DQA:	Date:	;
NCR: Y	'es /	No				WORK ORDER NON-C	O	NFORM	AANCE / UPDATE				
											QA Closed:	Date:	
Work Orde	ar.				:	DISPOSITION			AG	GAINST DE	PARTMENT	/PROCESS	
WOIK OIGE						Rework	1		Skid-tube Cro	sstube		Water Jet	Engineering
Part N	۱o					Scrap			—	nall Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is		1	_ 	nishing	Rec/Sto	re/Packaging	Other
NCR N	No					Work Order Update]		Large Fab Con	nposite		Supplier	
Root					Descri	ption of work order update		Initial	Action		Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Description	1	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling							l						
Operator	Ш									:			
Material													
Setup	* -												
Other													
Process													
Supplier							}						
Training													
Unapproved							ĺ						
						F	AUI	T CATE	GORY			•	
Landi	ng Gea	ar				General		_			_		
	Ве	ending				Bend		Grain			Ovalized		Pressure/Forced
	C€	entre No	t Concer	ntric to (o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cr	acks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
	Cr	ushed/0	Crimped			Burrs		Instruct	ions Incomplete/Unclear	r 📗	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cu	ıffs		4		Contamination		Mainte	nance		Part Moved	_	_
:	Пне	eat Trea	t			Countersink	Г	Mislabe	led		Positioned V	Vrong	
	∏in	spection	Strip in	Tube		Cut Too Short		Misread			Power Loss/	Surge	Other
	Ri	pples in	Bend			Drill Holes		Offset			•		

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

Picklist Print

May-27-13 12:41:59 PM

Work Order ID:

102241

Parent Item:

D4095-047

Parent Item Name:

Wearpad Assembly

Start Date: 6/14/13

Required Date: 6/14/13

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP rev.A 11.11.07 new issue EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No				sf	446.0842	And	, =0.588	2 -1 -//	۸	
304/316 Sheet .063										EL 1	5-6-70		
				Location		Loc Qty	. <u>L</u>	oc Code					
				MAT020		446.0841688							
				122	245	0.1713688							
				123	136	140.8							
				124	428	23.61							

25.5028

256

124572

125599

Page 1

											DQA:	Date	·
NCR: Ye	es /	No				WORK ORDER NON-C	ON	IFORM	MANCE / UPI	DATE			
				*							QA Closed:	Date	•
Nork Ordei	÷:					DISPOSITION				AGAINST DI	PARTMENT/	PROCESS	
Part N	***************************************					Rework Scrap Use-as-is		ſ	Skid-tube Machining noforming	Crosstube Small Fab Finishing	-	Water Jet J. Eng. Coor. e/Packaging	Engineering Quality Other
NCR N	o					Work Order Update			Large Fab	Composite	1 100	Supplier	
Root					Descri	ption of work order update		nitial	Act	tion	Sign &		
Cause	[Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector
oc/Data													
quip/Tooling							1						
perator													
Naterial													
etup													
ther	_												
rocess													
upplier											1		
raining													
Inapproved				<u> </u>	·								
						F	AUL	T CATE	GORY	·	·		
Landin	g Gea	r				General				_	_	م	
	Be	nding				Bend	L	Grain		_	Ovalized		Pressure/Forced
	Ce	ntre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cr	acks				Broken/Damaged	L	Inspecti	ion Incomplete		Part Incorrec	t _	Weld
	Cr	ushed/0	Crimped			Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/Mis	ssing	Wrong Stock Pulled
	Cu	ffs			ļ	Contamination		Mainte	enance	L	Part Moved		
	Не	at Trea	t			Countersink		Mislabe	eled		Positioned W	/rong	_
	Ins	pection	n Strip in	Tube		Cut Too Short		Misread	d		Power Loss/S	Surge	Other
[Ri	ples in	Bend			Drill Holes		Offset					
	То	rque W	aves in E	xtrusio	n [_	Drawing		Out of 0	Calibration				
	Tu	rning S	equence			Finish		Out of 9	Sequence				
	w	ave/Tw	ist in Tub	эе		Folio		Outside	Dimensions			· · · · · · · · · · · · · · · · · · ·	

DART AEROSPACE LTD	Work Order:	102241
Description: Wearpad	Part Number:	D4095-7
Inspection Dwg: D4095 Rev: B		Page 1 of 1

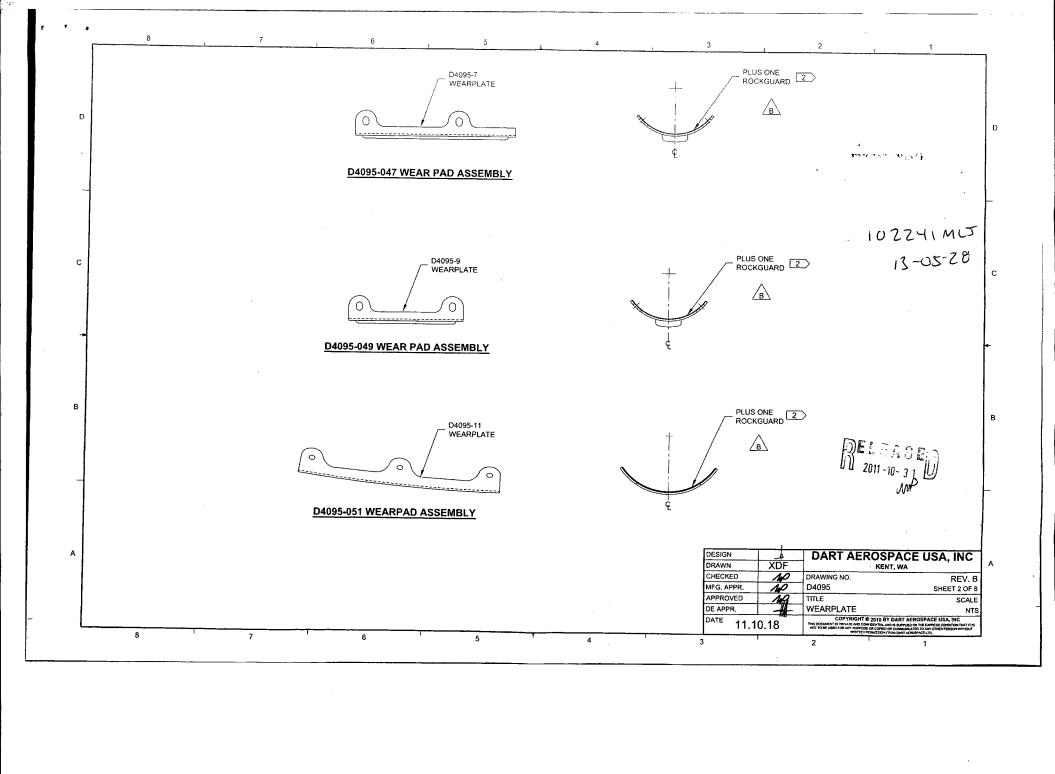
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.220	+/-0.010	0.226	~		V JKM-01	
0.380	+/-0.010	0.380		****	4	
1.965	+/-0.010	1.769	4		''	
2.795	+/-0.010	2-795	-		"	
3.500	+/-0.010	2-795	~		//	
5.86	+/-0.030	5.854	~		11	
3.63	+/-0.030	3.623	<u></u>		11	
0.063	+/-0.010	0.057			11	
						,

Measured by:	al m	Audited by: 16	Preliminary Approval:	
Date:	13-6-10	Date: 7.60	lic Date:	

Rev	Date	Change		Revised by		Approved
Α	11.11.08	New Issue	P/O D4095-047	KJ Q	M	11
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